

Work Order ID 98861

April-11-13 9:47:56 AM

Setup Monday 22/04
98861

Page 1

Item ID: D4078-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp Half

Start Date: 3/27/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/10/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 130411 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4078	B

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.700" long

3FC/pa 2013-04-16

20

0

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA929

Folio rev: AA

Dwg Rev: B

Deburr

DAS
0221
-39

13-04-18

x20

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Page 2

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

D40
02
13-04-18 ***20***

FK 13/04/19

20 0

20X of M-13/04/22

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SHIP BY 22/04
98861

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

150

Powdercoat

Memo

Powder Coating

0.00

Start Time: 10:30
Temp: 3200F
Finish Time: 11:00

20 X 1 M/L 13/04/22

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

Quality Control

0.00

20 13-4-22

170

Identify as per dwg & Stock Location: ST052 0.00

170

Packaging

Memo

Packaging

0.00

4/3/4/22 (20)

Picklist Print

April-11-13 9:48:01 AM

Page 1

Work Order ID: 98861

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Parent Item: D4078-1

D4078-1

Parent Item Name: Clamp Half

Start Date: 3/27/13

Required Date: 4/10/13

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	41.0448	0.223	4.694737			

M6061T6B1 250X01 250

6061-T6 Bar 1.25 x 1.25

**

Location

Loc Qty

Loc Code

MAT003

41.0448421

122521

0.6638421

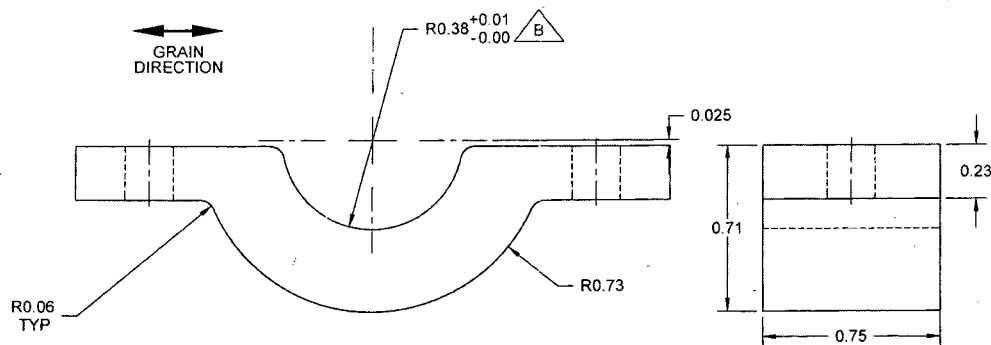
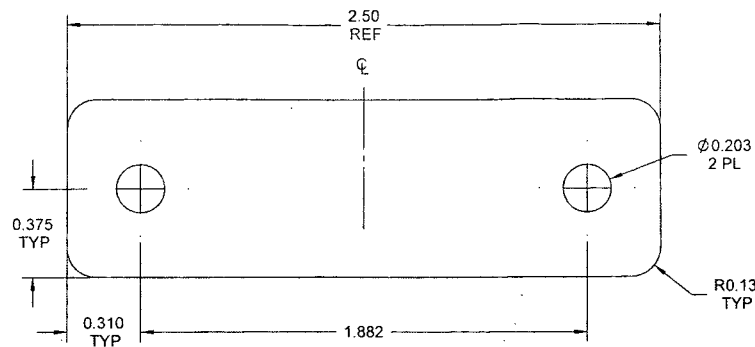
123649

2.978

124443

37.403

4.6947 OFC/B 2013-04-16



D4078-1 CLAMP HALF

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

B	R0.38 was R0.48.	LB	10.07.30
A	NEW ISSUE	LB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN	LB		
DRAWN	LB		
CHECKED	LB		
MFG. APPR.	LB		
APPROVED	LB		
DE APPR.	LB		
DATE	10.07.30		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4078** REV. B
SHEET 1 OF 1

TITLE **CLAMP HALF** SCALE NTS

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STAMP
RECEIVED
ENGINEERING
UNCONTROLLED
SUBJECT
WORK
98861-MCS
13-04-11

